

Block for SO 101889

Work Order ID 58238

Friday, April 30, 2010 1:02:09 PM

Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: MF Date: 10-4-30 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3913	A
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100	Weld per dwg A/R S.S. rod Batch: 111677	0.00							
-----	---	------	--	--	--	--	--	--	--

Large Fab									
-----------	--	--	--	--	--	--	--	--	--

Memo

1- assemble ribs , weld as per dwg D3913
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

QC									
----	--	--	--	--	--	--	--	--	--

Quality Control

Memo

Cpl 10.05.12

10.05.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 58238

Friday, April 30, 2010 1:02:09 PM

Page 2

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	4/30/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	5/21/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O <i>Fit to his as right</i> Memo	0.00 0.00							
130  Powdercoat Powder Coating	White Gloss (Ref:4.3.5.2) per QSI005 4.3-Steel <i>Black Sandex per customer Wood Buffalo =></i> Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>1112588</i> 1ST COAT: START TIME: <i>2:30pm</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>3:00pm</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: <i>3:15pm</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>3:45pm</i>	0.00 0.00				<i>1</i>	<i>0</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Stop



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Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Ep 10/05/13 ②

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

Pick Kit

0.00

Ep 10/05/13 ①

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Sc 10/05/14**④*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

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Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location:

C-A

0.00

Memo

w/o 58313

0.00

9510/05/13 @

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

100514
MF
10-5-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, April 30, 2010 1:02:08 PM

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Work Order ID: 58238

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	112.0000	6		4/5/10/05/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351		112						
					111119	12						
					114330	100						
AN960JD8 Washer		Purchased	No			150	Each	0.0000	2		6-5-14	
D2581 Mounting Bracket		Manufactured	No			100	Each	27.0000	2		4/10-05-06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		27						
					46086	2						
					51745	2						
					57185	23						
D2931 Bumper		Manufactured	No			150	Each	872.0000	2		4/5/10/05/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		872						
					46064	872						
D3913-1 Rib		Manufactured	No			100	Each	0.0000	1		358124 → ① 4/10-05-06	

W/O:		WORK ORDER CHANGES					
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Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3913-15		Manufactured	No			100	Each	2.0000	1			

Wide Handle Plate

358125 → ① Pl 10.05.06

Location Loc Qty Loc Code

WA	2	
57079	2	

D3913-3 Manufactured No

100 Each 7.0000

Rib

Pl 10.05.06

Location Loc Qty Loc Code

WA	7	
57609	1	
58126	6	

D3913-7 Manufactured No

100 Each 0.0000

Rib

358127 → ① Pl 10.05.06

D3913-9 Manufactured No

100 Each 1.0000

Hinge Rib

Pl 10.05.06

Location Loc Qty Loc Code

WA	1	
57610	1	

D3916-041 Manufactured No

100 Each 0.0000

Rib Assembly

358128 → ① Pl 10.05.06

358357 → ② Pl 10.05.06

Friday, April 30, 2010 1:02:08 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58238



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3916-5		Manufactured	No			100	Each	2.0000	3			

✓ Light Rib

Location Loc Qty Loc Code

WA 2
57023 2

✓ D4016-1 Manufactured No

Hinge Half, Base

Location Loc Qty Loc Code

ST109 4
57611 4

✓ D4017-7 Manufactured No

Rib

✓ D4017-9 Manufactured No

Rib

✓ D4020-1 Manufactured No

Mesh (350 Basket Long, Base)

✓ D4020-11 Manufactured No

End Mesh, Basket

Location Loc Qty Loc Code

WA 1
56990 1

358360 → ③



PL 10-05-06

358132 → ③



358133 → ① PL 10-05-06



358134 → ② PL 10-05-06



358135 → ① PL 10-05-11



PL 10-05-11

358136 → ②

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Page 3

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 58238

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Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D4021-1
Handle Plate

Manufactured No

100 Each 7.0000

3
358189 → ③ Pl 10.05.06

Location Loc Qty Loc Code

ST109 7
57086 7

D4021-5
Blanking Plate

Manufactured No

150 Each 4.0000

2
Ep 10/05/13
58673
58740 ②

Location Loc Qty Loc Code

ST109 4
57612 4

✓ D4034-041
Aft Upper Rib Assembly

Manufactured No

100 Each 4.0000

1
Pl 10.05.06

Location Loc Qty Loc Code

WA 4
57988 4

↓ D4034-043
Fwd Upper Rib Assembly

Manufactured No

100 Each 4.0000

1
Pl 10.05.06

Location Loc Qty Loc Code

WA 4
58040 4

Friday, April 30, 2010 1:02:09 PM

Shop Packet Print

Page 4

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 58238



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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20600-AD4W3		Purchased	No			150	Each	1,891.000	2			
Cherry Rivets												

Location	Loc Qty	Loc Code
ST321	1891	
106375	3	
107939	888	
111636	1000	

EP 5/10/05/13

MS21042L3	Purchased	No				150	Each	1,816.000	6			
Nut												

Location	Loc Qty	Loc Code
ST300	1816	
113537	20	
113644	796	
114523	1000	

EP 5/10/05/13

NAS1149F0332P	Purchased	No				150	Each	959.0000	12			
WASHER												

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

EP 5/10/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

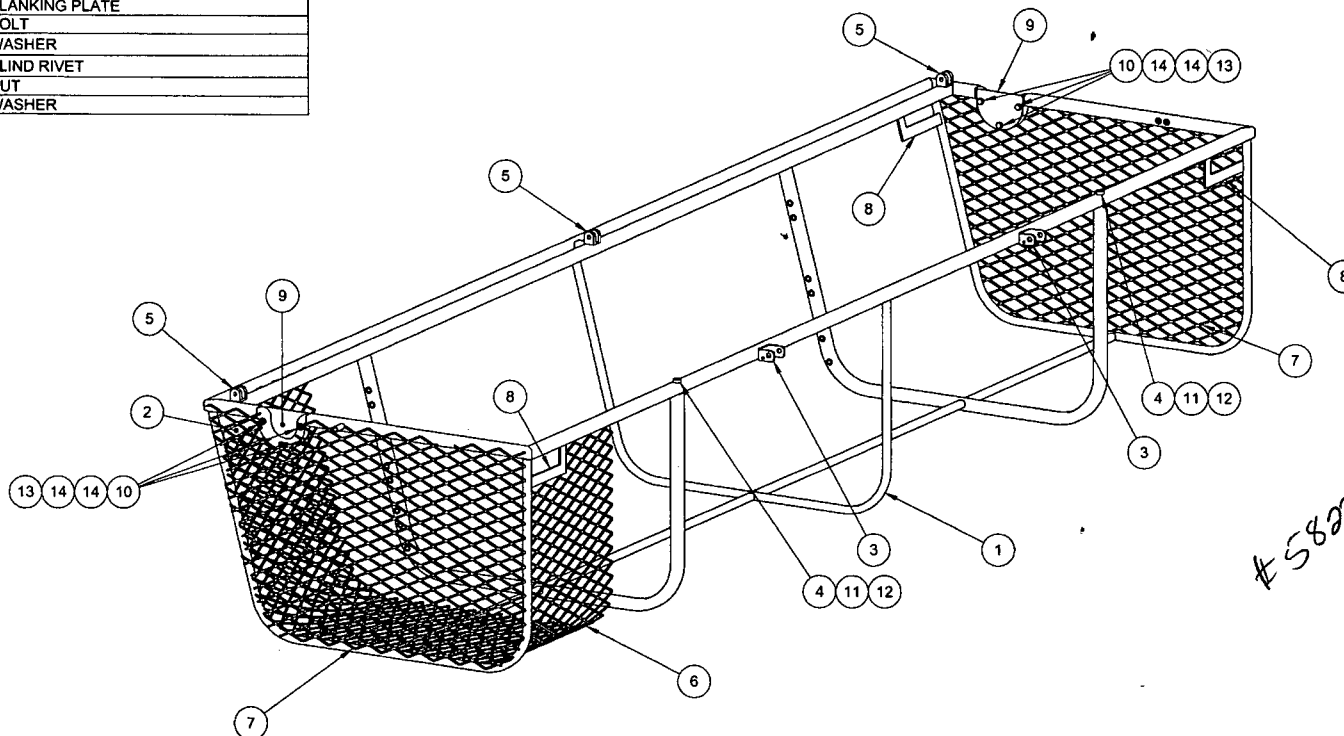
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



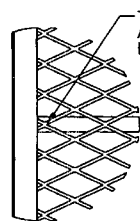
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

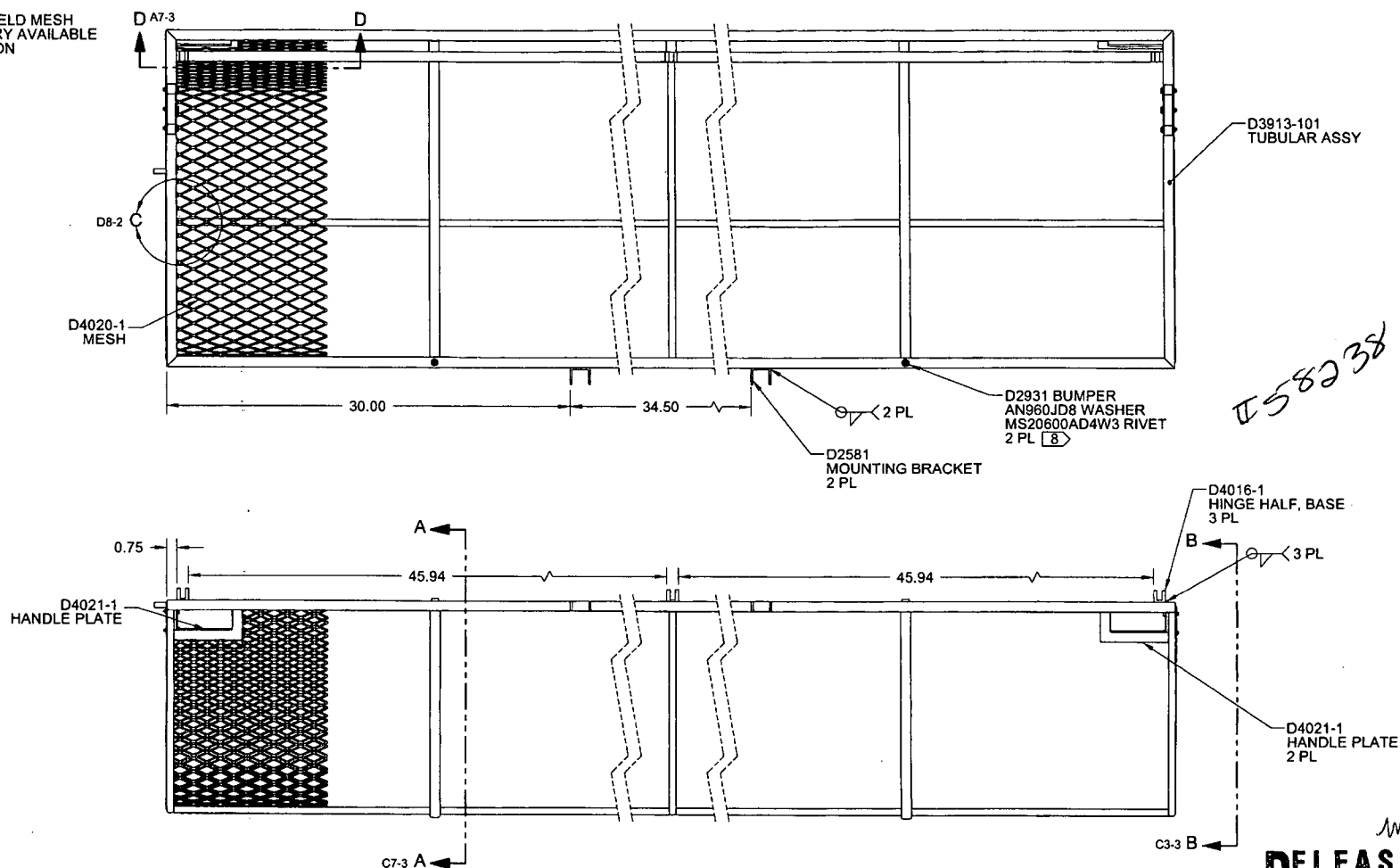
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JWP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



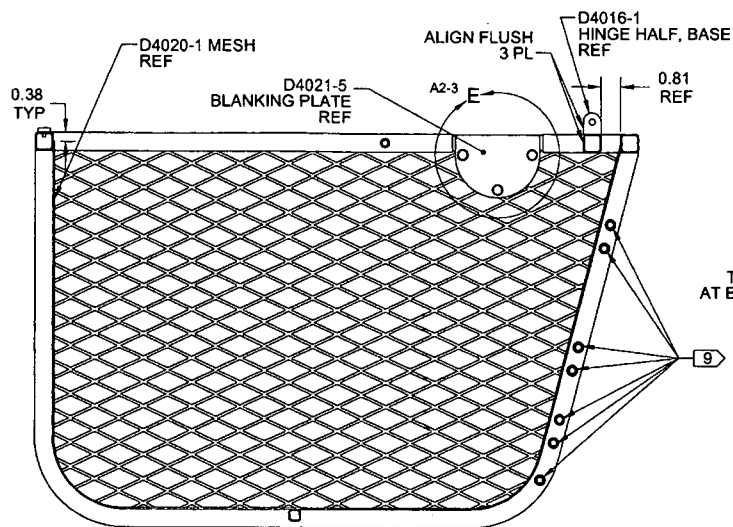
DETAIL C D7-2



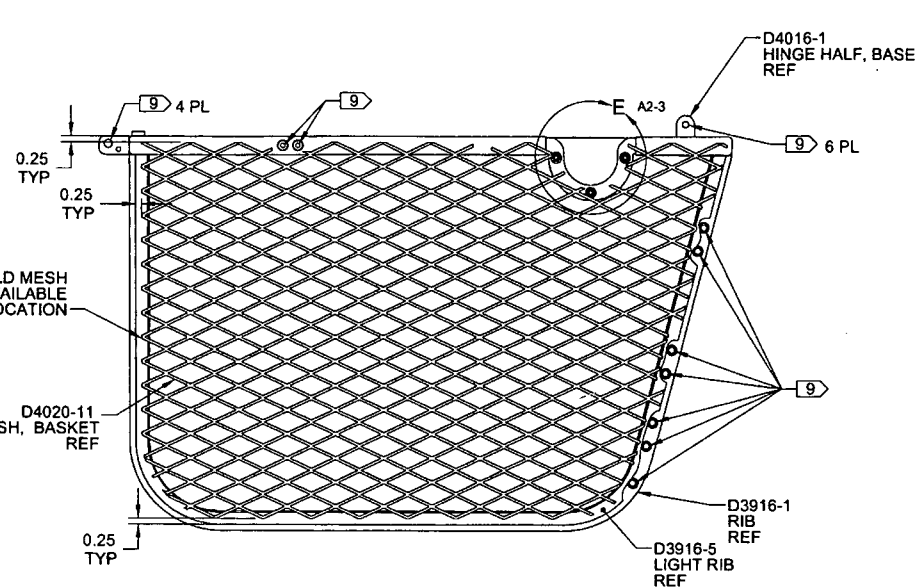
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

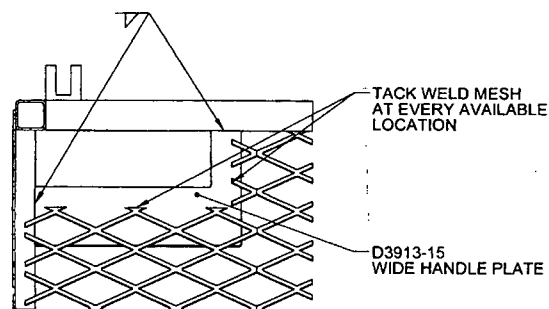
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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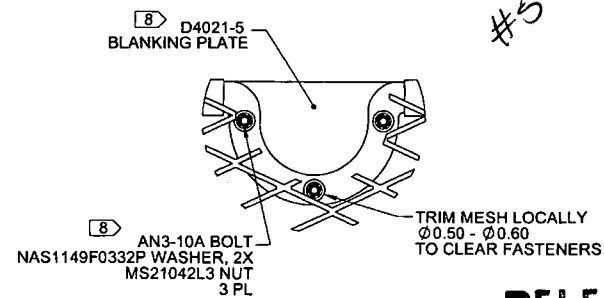
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



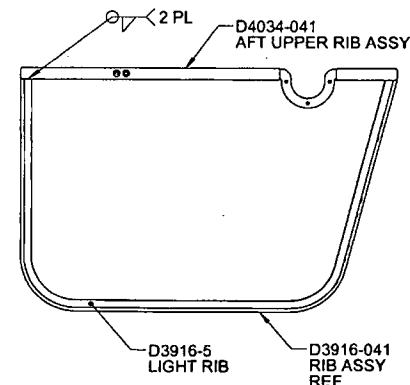
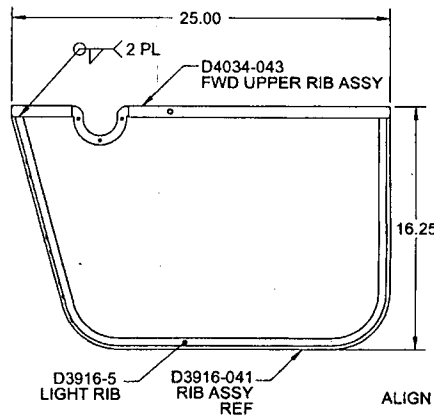
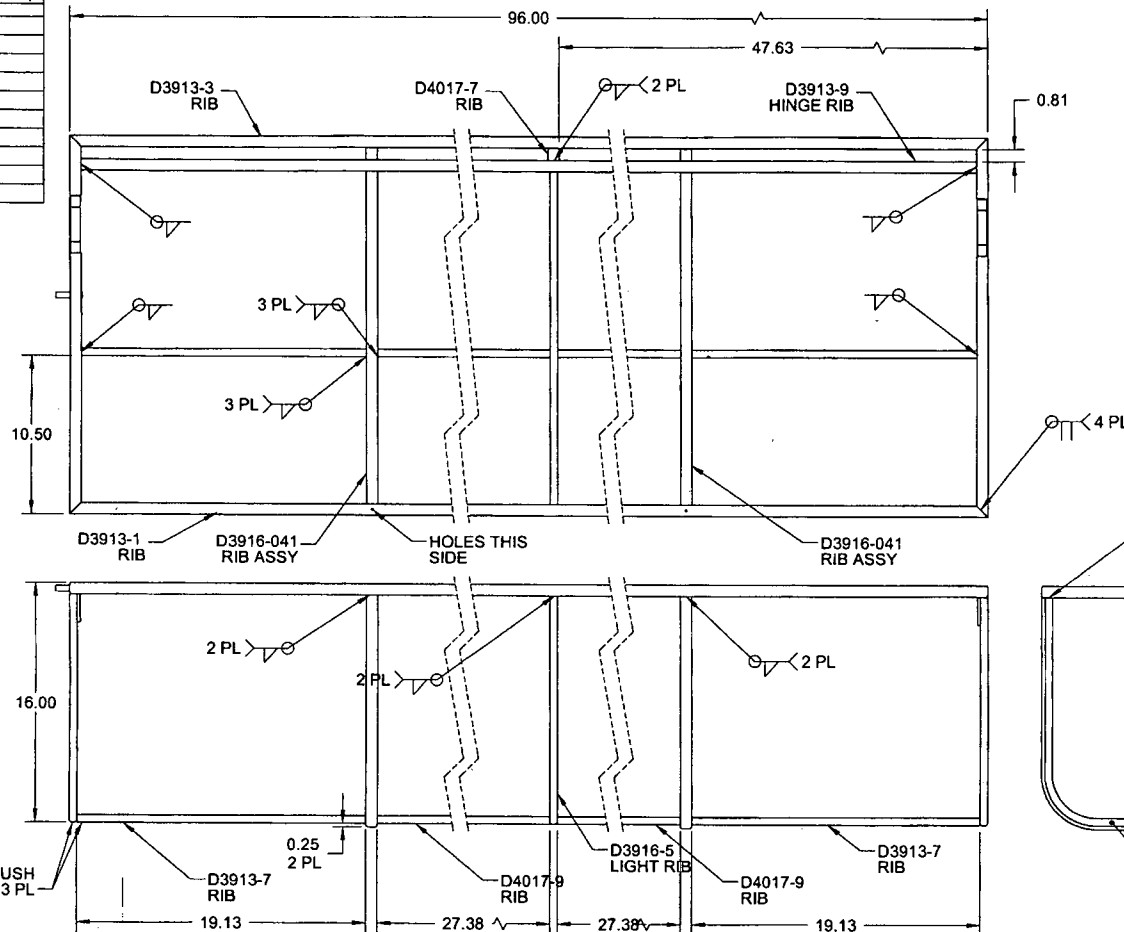
DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-03-22

#58238

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

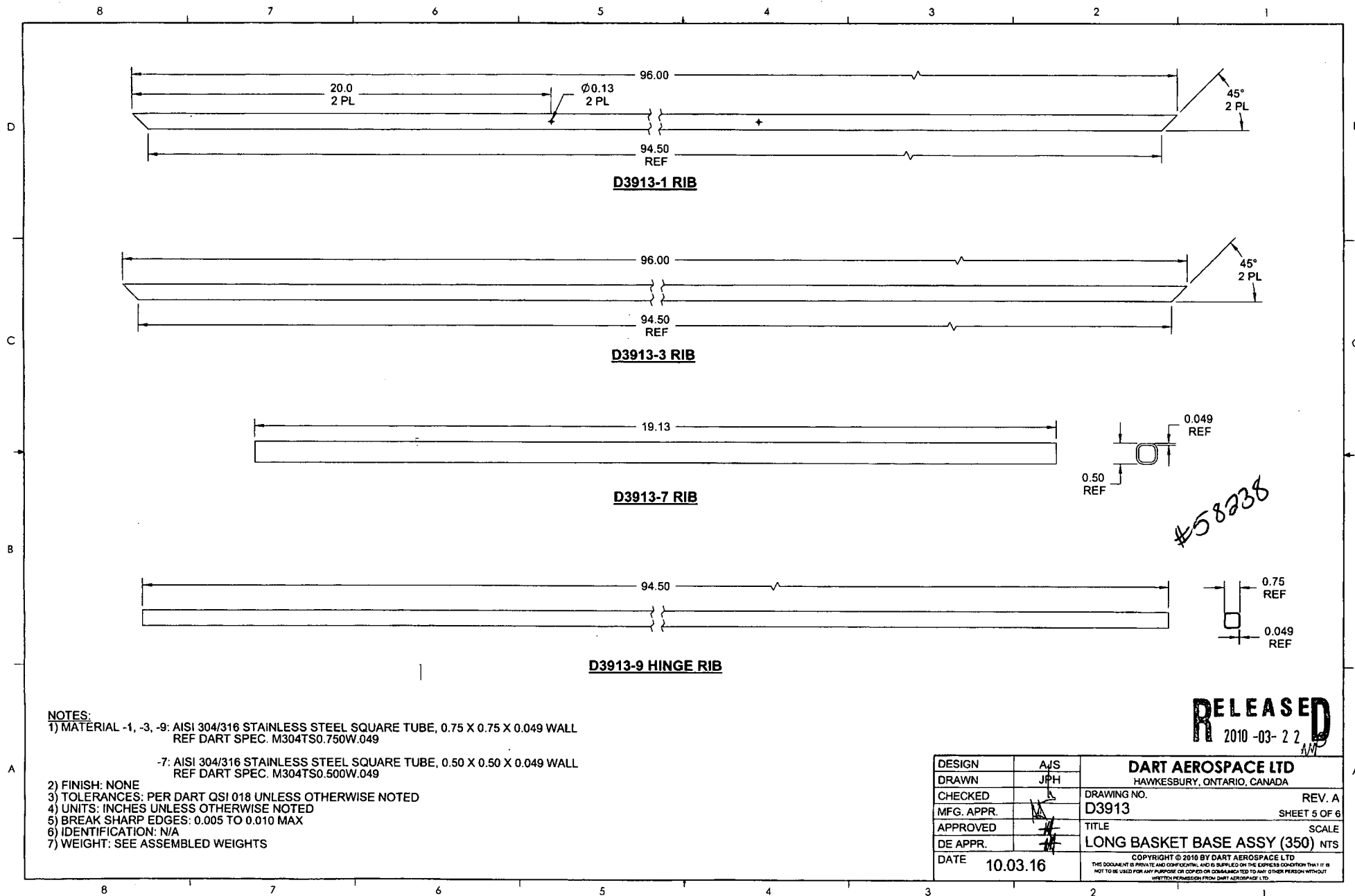


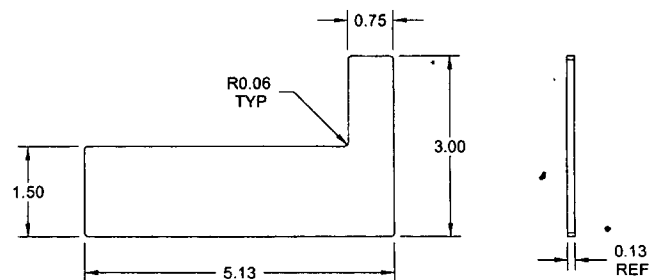
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO. D3913	REV. A
MFG. APPR.		SHEET 4 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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2010-03-22
JMP

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